

# Work Order ID 76382

**\*76382\***

Page 1

November-11-11 9:22:57 AM

Item ID: D2221 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 350 Basket Base  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 21/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								

100 0.00

**\*100\***

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
 3- tack weld mesh on basket as per dwg D2221  
 A/R ER316 S.S. Rod Batch: 114649

\*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
 DRILL HOLES FOR GAS SPRING  
 IN D3825-041 AS PER  
 DSI 9473

*Handwritten: 1x 0*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

*Handwritten: BE 11-12-22*

*Handwritten: 1 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
<b>*125*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

*Handwritten signature: N. M. L. 11/12/28*

W/O:		WORK ORDER CHANGES					
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Required Date: 21/11/2011      Req'd Qty: 1.00      **\*1\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*130\***

Powdercoat

Powder Coating

**Memo**

1- Plug holes prior to

1ST COAT:

START TIME: 9:30OVEN TEMPERATURE: 400°FFINISH TIME: 12:00

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Quality Control

**Memo**

0.00

5/12/01/04

X/M-L 11/12/28

M119480

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
<b>*150*</b>	<i>W6 76371</i>	0.00				<i>1</i>	<i>12-1-4</i>		
Packaging	Memo								
Packaging	<i>D380-607-043</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>		0.00							<i>CK 12/01/05</i>
QC	Memo								
Quality Control									<i>ME 12-01-04</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

November-11-11 9:23:02 AM

Page 1

Work Order ID: 76382

\*76382\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1		Manufactured	No			100	Each	16.0000	1	1			
*D2221-1*									**				
Rib													

Location	Loc Qty	Loc Code
WA	16	
71372	4	
72297	12	

D2221-5		Manufactured	No			100	Each	12.0000	2	2			
*D2221-5*									**				
Rib													

Location	Loc Qty	Loc Code
WA	10	
71218	10	
WA006	2	
67117	2	

D2221-7		Manufactured	No			100	Each	8.0000	1	1			
*D2221-7*									**				
Rib													

Location	Loc Qty	Loc Code
WA	5	
71219	1	
73203	4	
WA006	3	
72731	3	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76382

\*76382\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each

20.0000

2

2

/ \*D2232-3\*

Basket Hinge

\*\*

*Pl 11.12.21*

Location

Loc Qty

Loc Code

WA

20

75581

20

D2235-1

Manufactured No

100 Each

5.0000

2

2

/ \*D2235-1\*

Basket Rib

\*\*

*Pl 11.12.21*

Location

Loc Qty

Loc Code

WA

1

73202

1

WA005

4

66895

4

D2581

Manufactured No

100 Each

23.0000

2

2

/ \*D2581\*

Mounting Bracket

\*\*

*Pl 11.12.21*

Location

Loc Qty

Loc Code

WA

23

69739

2

70766

2

73762

19

D3442-1

Manufactured No

100 Each

19.0000

2

2

/ \*D3442-1\*

Shim

\*\*

*Pl 11.12.21*

Location

Loc Qty

Loc Code

WA

19

71224

4

71783

15

November-11-11 9:23:02 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 76382

\*76382\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100 Each

6.0000

2 2

\*D3825-041\*

Rib Assembly (Basket End)

\*\*

*Cpl 11.12.21*

Location

Loc Qty

Loc Code

WA006

6

72727

6

②

D3826-041

Manufactured No

100 Each

10.0000

2 2

\*D3826-041\*

Rib / Gusset Assembly

\*\*

*Cpl 11.12.21*

Location

Loc Qty

Loc Code

WA

10

72728

4

73749

6

B 77464 → ②

D3827-041

Manufactured No

100 Each

9.0000

1 1

\*D3827-041\*

Rib Assembly (Inboard)

\*\*

*Cpl 11.12.21*

Location

Loc Qty

Loc Code

WA

9

72083

3

72729

6

①

D3832-1

Manufactured No

100 Each

2.0000

1 1

\*D3832-1\*

Mesh (Base)

\*\*

*Cpl 11.12.21*

Location

Loc Qty

Loc Code

WA

2

72702

2

B 73748 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 76382

\*76382\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

12.0000

2

2

\*D3833-1\*

Mesh (Base End Face)

\*\*

Pl 11.12.21

Location

Loc Qty

Loc Code

WA

12

70470

6

71834

1

72866

5

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

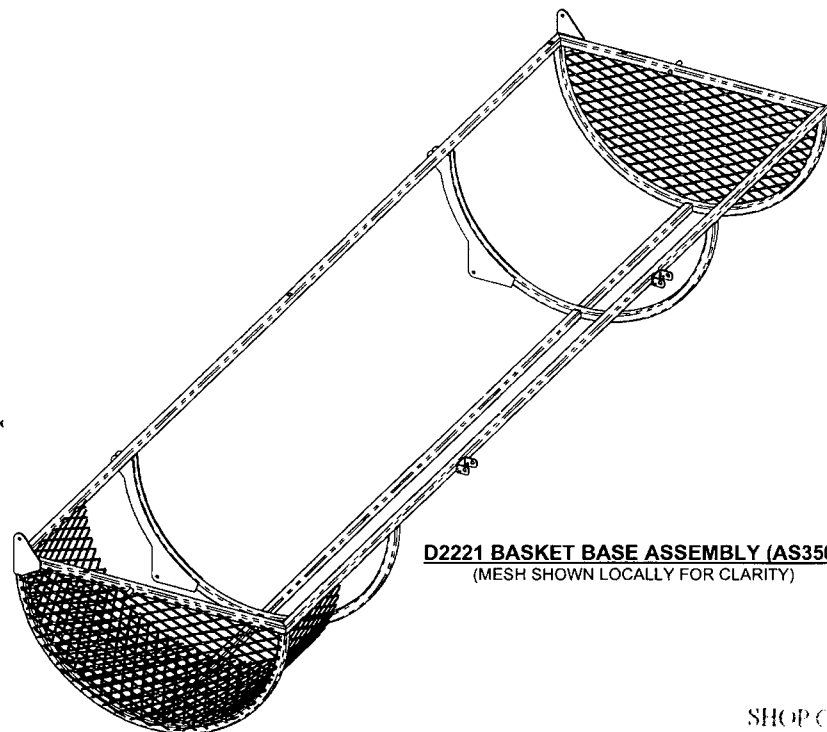
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**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 76382 M.L.J

11/11/11

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

A

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISED  
08/11/11

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

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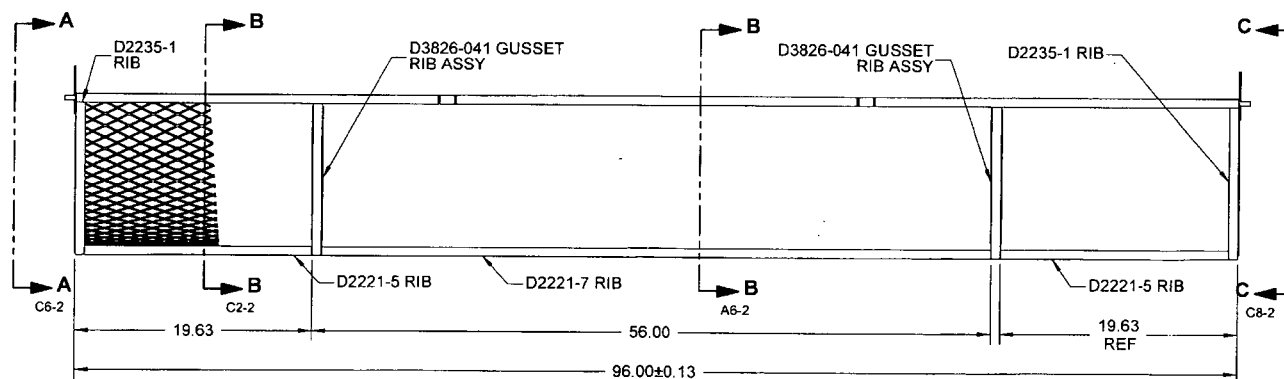
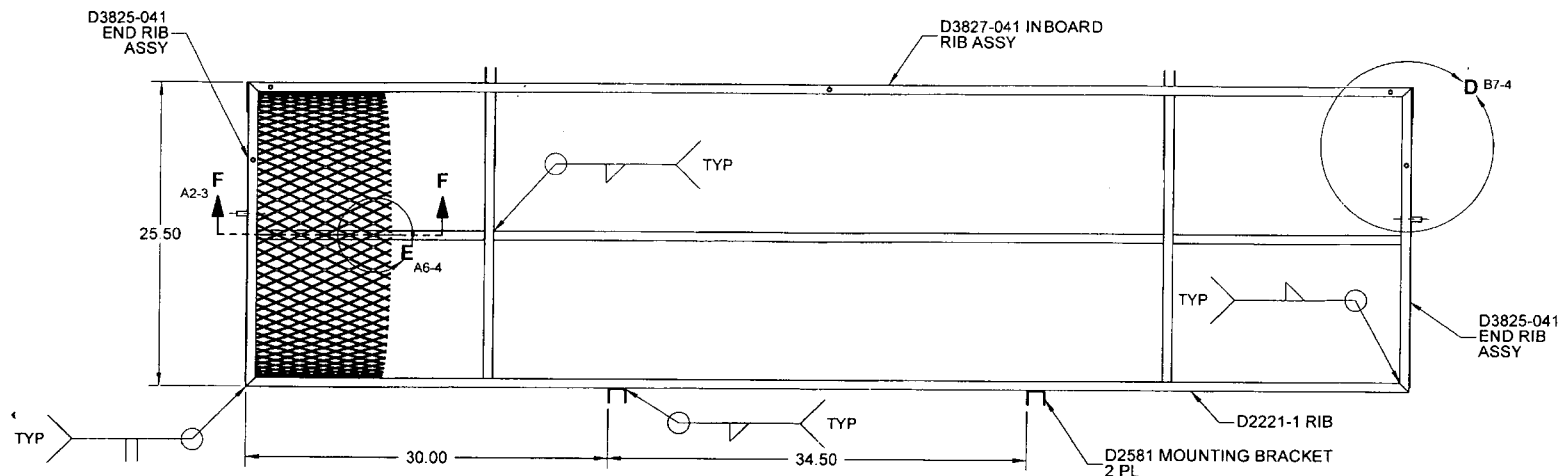
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**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
06/11/18

DESIGN	EW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b>	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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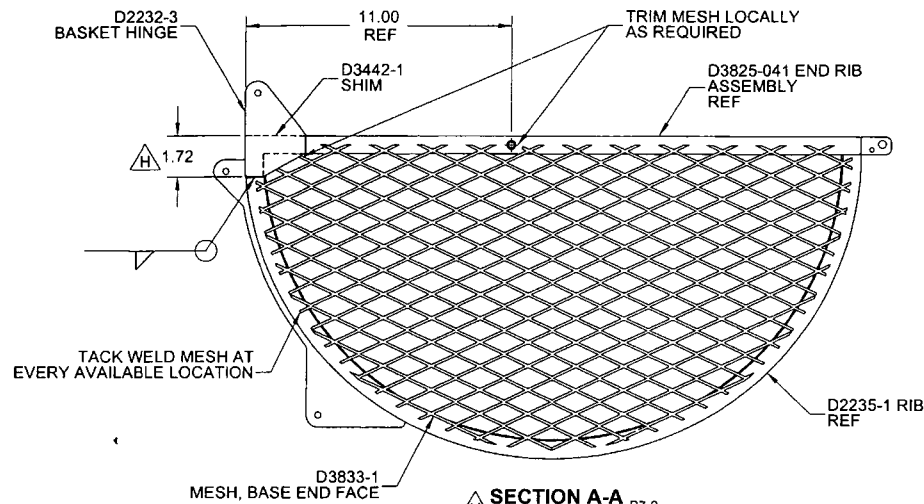
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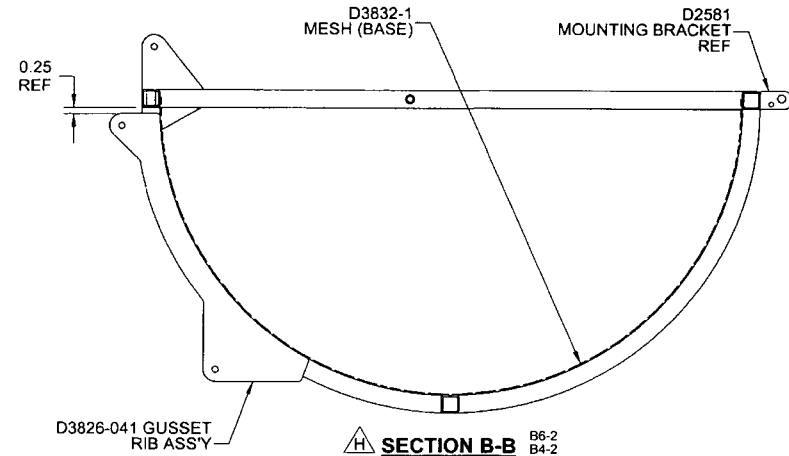
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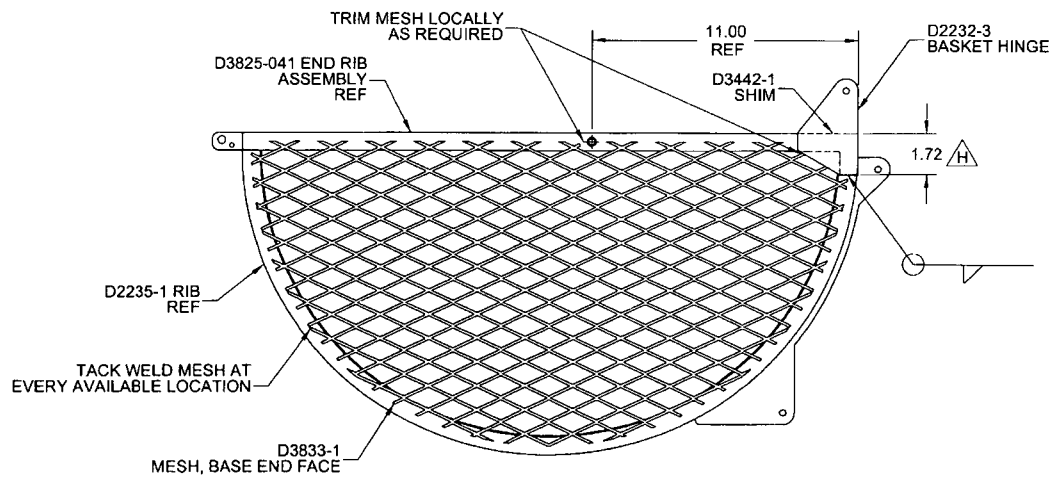
76382



**SECTION A-A**  
SCALE 2X B7-2



**SECTION B-B**  
SCALE 2X B6-2 B4-2



**SECTION C-C**  
SCALE 2X B2-2

RELEASED  
02/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.	JS		SHEET 3 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>BASKET BASE ASSEMBLY (350)</b>	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

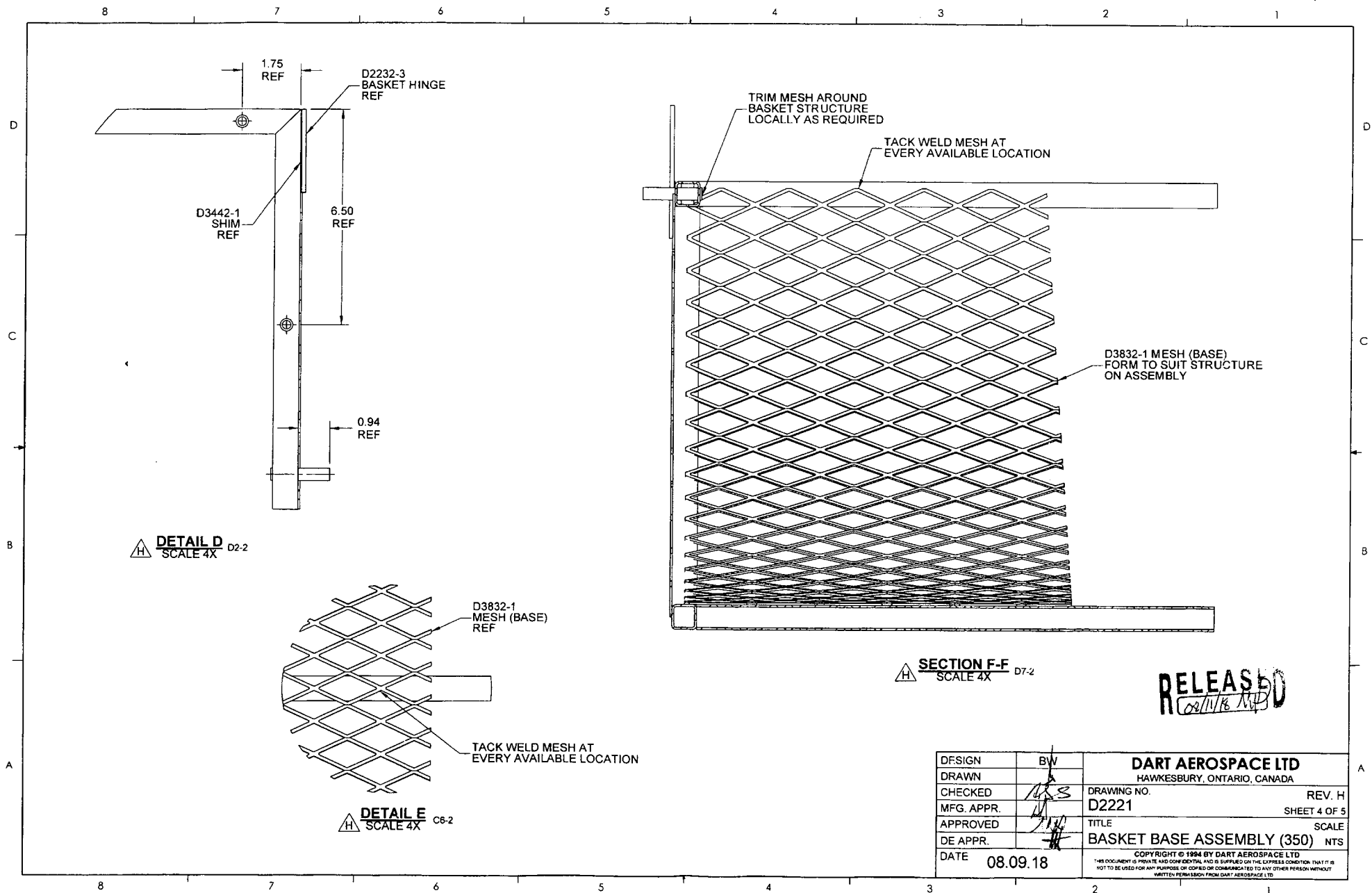
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76382



RELEASED  
 08/11/16

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	1453	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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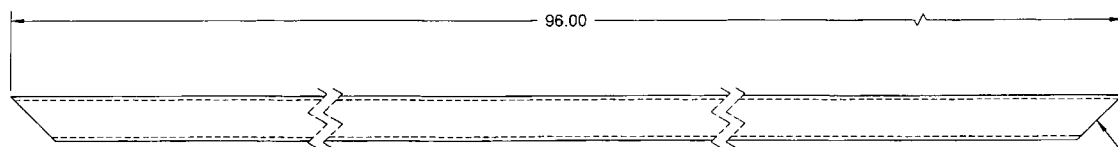
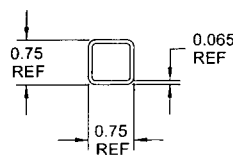
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

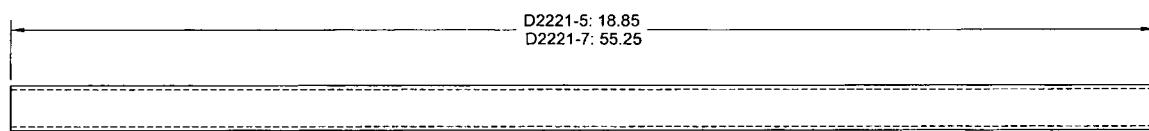
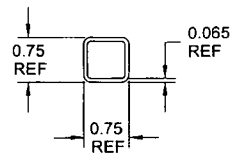


76382



**D2221-1 RIB**

0.75 X 45° CHAMFER  
2 PL



**D2221-5/-7 RIB**

**RELEASED**  
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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